

Work Order ID 52641

October 5, 2009 11:46:41 AM

Oct-6



Item ID: D3238-31

Accept



Setup Start



Revision ID: C

Stop



Item Name: Plate

Start Date: 10/05/09 Start Qty: 12.00



Cust Item ID:

Required Date: 10/06/09 Req'd Qty: 12.00



Customer:

Reference:

Approvals:

Process Plan:

[Signature]

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3238

Rev C

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3238 Dwg Rev: C Prog Rev: C 2-
Deburr if necessary ***Use cutting file D3238-21-23-25*****

2-Deburr

m. l. 09/10/15 (14X) (14)

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

13 9-10-5

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

=> Sorlus66

(14X) /

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Item ID: D3238-31

Revision ID: C

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Start Date: 10/05/09 Start Qty: 12.00

Required Date: 10/06/09 Req'd Qty: 12.00

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Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

MD 09/10/06

X/14

Hand Finishing

140

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

BR 09-10-6

(14)

Quality Control

150

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

0.00

09/10/6 (14)

Packaging

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Item ID: D3238-31

Accept



Setup Start



Revision ID: C

Stop



Item Name: Plate

Start Date: 10/05/09 Start Qty: 12.00



Cust Item ID:

Required Date: 10/06/09 Req'd Qty: 12.00



Customer:

Reference:

Run Start



Approvals: Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

09/10/07

MF 09-10-06

Picklist Print

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Work Order ID: 52641

Parent Item: D3238-31RevC

Parent Item Name: Plate


Comments:

Start Date: 10/05/09

Required Date: 10/06/09

Start Qty: 12.00

Required Qty: 12.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6S.020		Purchased	No			100	sf	38.5700	0.3032	14		
												
6061-T6 Sheet .020												

B 9-10-5

Warehouse
Location

Loc Qty

Loc Code

Main Warehouse

MAT

112442

38.57

38.57

112442

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order: 52641
Description: Plate		Part Number: D3238-31
Inspection Dwg: D3238	Rev: C	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.203	+0.005/-0.001	.207	X			
0.40	+/-0.030	.394	X			
0.33	+/-0.030	.325	X			
1.96	+/-0.030	1.962	X			
1.300	+/-0.010	1.302	X			
1.75	+/-0.030	1.748	X			
0.950	+/-0.010	.947	X			
0.80	+/-0.030	.80	X			
0.65	+/-0.030	.656	X			
0.650	+/-0.010	.651	X			

Measured by: RB	Audited by: S. J. J. J.	Prototype Approval:	N/A
Date: 9-10-5	Date: 02/10/06	Date:	N/A

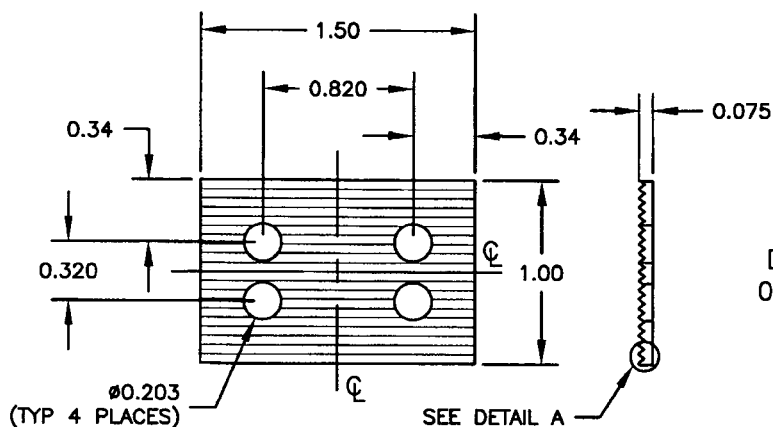
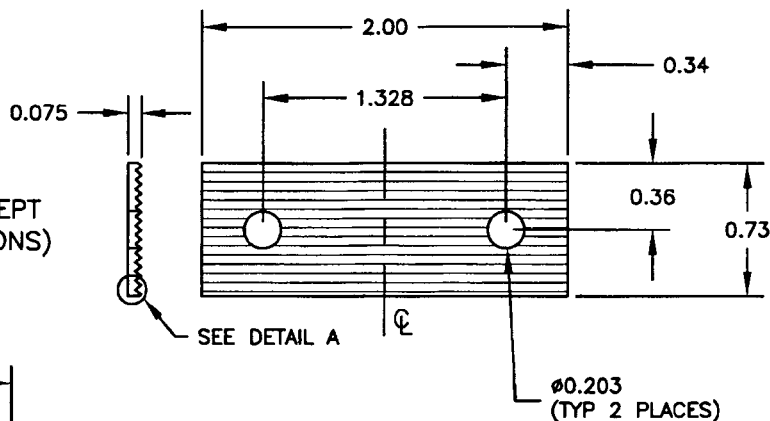
Rev	Date	Change	Revised by	Approved
A	08.02.28	New Issue	KJ/DD	



DESIGN #	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED LE	APPROVED #	DRAWING NO. D3238	REV. C SHEET 1 OF 3
DATE 07.02.19	TITLE PLATE		SCALE 1:1
A	03.11.25	NEW ISSUE	
B	07.01.17	ADD -21/-23/-25/-31/-33/-35; CHANGE -11/-13/-15 TO 6061-T6	
C	07.02.19	ADD 5052-H32 OPTION	

RELEASED
07.02.20

D3238-1 PLATE (SHOWN)
D3238-11 PLATE (SAME, EXCEPT
0.020 THICK AND NO SERRATIONS)



D3238-3 PLATE (SHOWN)
D3238-13 PLATE (SAME, EXCEPT
0.020 THICK AND NO SERRATIONS)

NOTES:

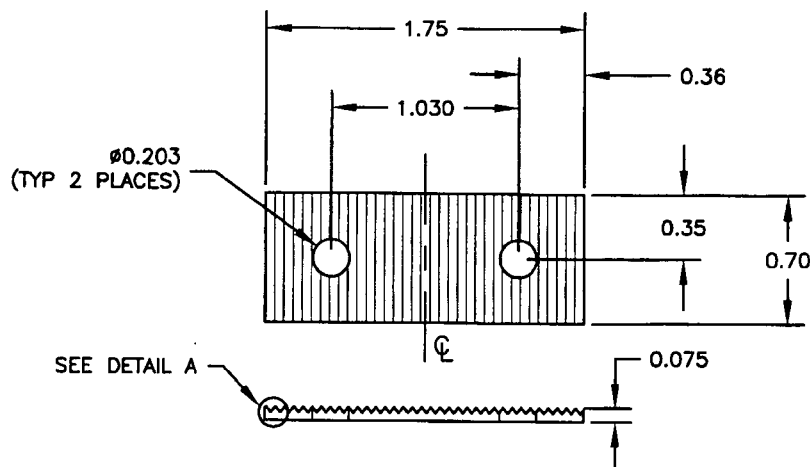
- 1) MATERIAL -1/-3/-5/-21/-23/-25 PLATE:
ALUMINUM 2024-T3 SHEET PER QQ-A-250/4 OR AMS 4037
(REF DART SPEC M2024T3S)
-11/-13/-15/-31/-33/-35 PLATE:
ALUMINUM 6061-T6/-T62 SHEET, 0.020 THICK, PER QQ-A-250/11 OR
AMS 4025 OR AMS 4027 (REF DART SPEC M6061T6S.020)
OR
ALUMINUM 5052-H32 SHEET, 0.020 THICK, PER QQ-A-250/8 OR
AMS 4016 (REF DART SPEC M5052H32S.020)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) SEE SHEET 3 FOR DETAIL A
- 7) PARTS ARE SYMMETRIC ABOUT ϕ

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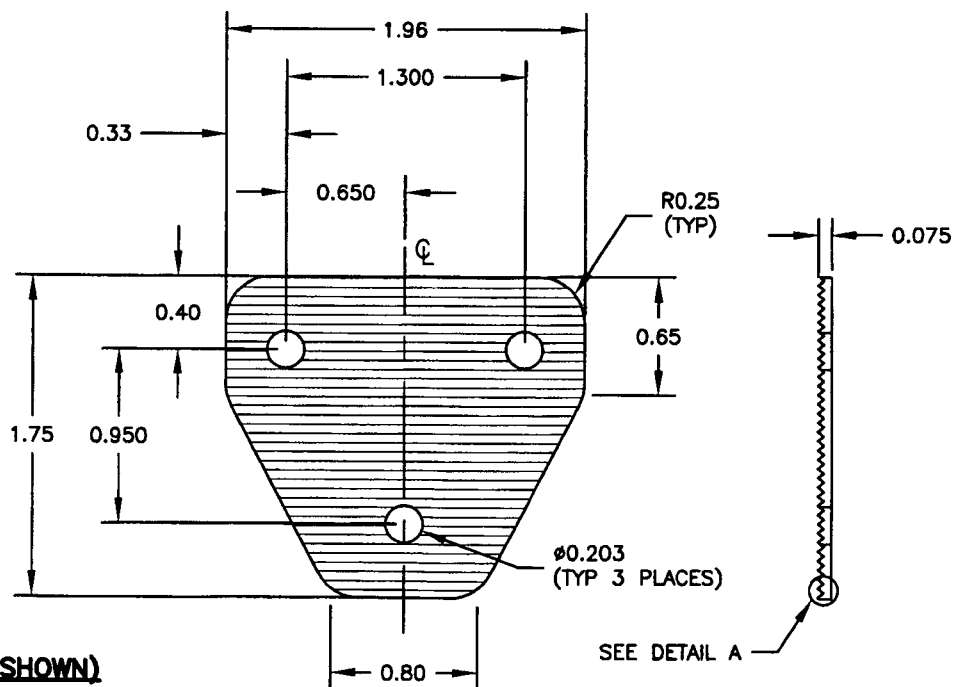
DESIGN #	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED LE	APPROVED #	DRAWING NO. D3238	REV. C SHEET 2 OF 3
DATE 07.02.19		TITLE PLATE	SCALE 1:1



RELEASED
07.02.20 #

D3238-5 PLATE (SHOWN)
D3238-15 PLATE (SAME, EXCEPT
0.020 THICK AND NO SERRATIONS)

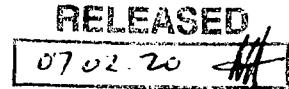
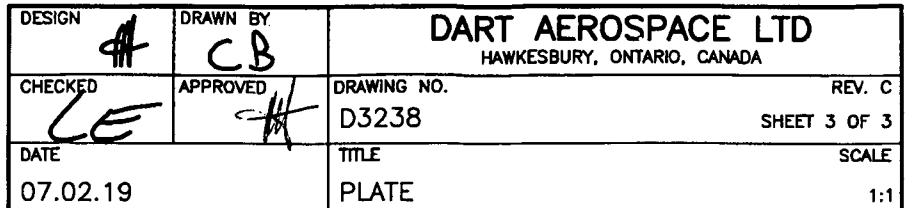
u/o 52641



D3238-21 PLATE (SHOWN)
D3238-31 PLATE (SAME, EXCEPT
0.020 THICK AND NO SERRATIONS)

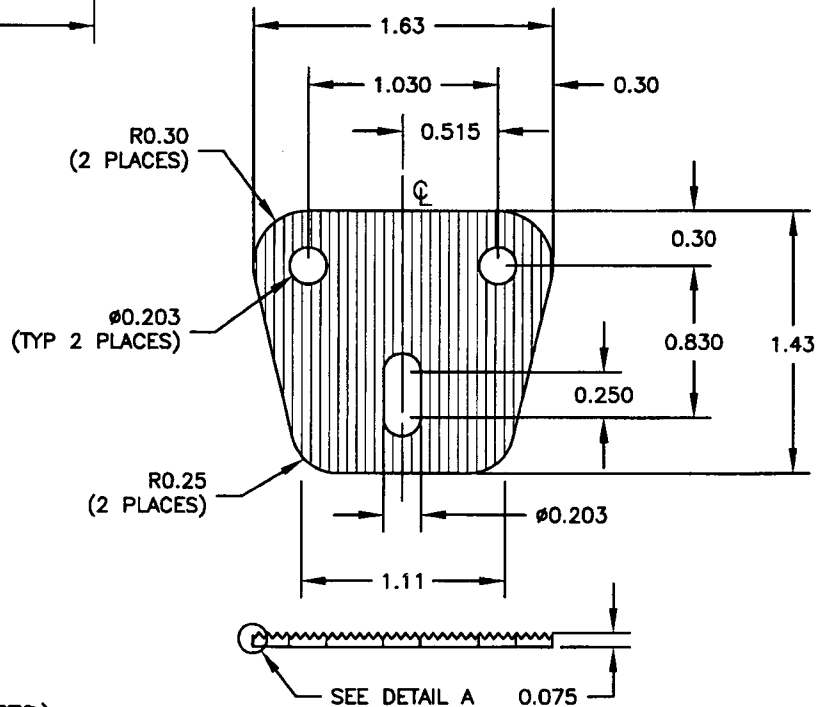
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D3238-23 PLATE (SHOWN)
D3238-33 PLATE (SAME, EXCEPT
0.020 THICK AND NO SERRATIONS)

no 52641



D3238-25 PLATE (SHOWN)
D3238-35 PLATE (SAME, EXCEPT
0.020 THICK AND NO SERRATIONS)

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